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1                   **Methods for Synthesis of Graft Polymers**2  
3                   **BACKGROUND OF THE INVENTION**4  
5                   **FIELD OF THE INVENTION**6     [0001]    The present invention relates to methods for the synthesis of branched polymers.  
7     More specifically, the present invention provides methods for the synthesis of polymers  
8     having a dendritic architecture.9  
10                  **DESCRIPTION OF THE PRIOR ART**11    [0002]    Synthetic polymers can take one of two general forms: linear or branched. Linear  
12    polymers are composed of a polymer backbone and pendent side groups inherent to the  
13    individual repeating units. Branched polymers have discrete units which emanate from the  
14    polymer either from the backbone or from the pendent groups extending from the individual  
15    repeating units. The branches have the same general chemical constitution as the polymer  
16    backbone. The simplest branched polymers, sometimes referred to as comb branched  
17    polymers, typically consist of a linear backbone which bears one or more essentially linear  
18    pendent side chains. Dendritic polymers are created by adding sub-branches to the branches  
19    extending from the main backbone. Dendritic polymers can be subdivided into 3 main  
20    categories: dendrimers, hyperbranched polymers and arborescent (or dendrigraft) polymers.  
21    Dendrimers are mainly obtained by strictly controlled branching reactions relying on a series  
22    of protection-coupling-deprotection reaction cycles involving low molecular weight  
23    monomers. Hyperbranched polymers are obtained from one-pot random branching reactions  
24    of polyfunctional monomers, resulting in a branched structure that is not as well defined as  
25    for dendrimers. Arborescent (or dendrigraft) polymers are obtained by successive grafting  
26    reactions of polymeric side chains on a polymer backbone.27    [0003]    Arborescent polymers are characterized by a tree-like or dendritic architecture  
28    incorporating multiple branching levels. These materials have a number of unique properties  
29    which make them potentially useful in a wide range of applications including controlled drug  
30    delivery vehicles, rheology modifiers for polymer processing, catalyst carriers,  
31    microencapsulation, and microelectronics (Esfand, R *et al* Drug Discovery Today 2001, 6,  
32    427.; Liu, M. *et al* Pharmaceutical Science and Technology Today 1999, 2, 393.; Gitsov, I. *et*

1      *et al* Micropheres, Microcapsules & Liposomes 2002, 5, 31.; PCT Patent Application WO  
2      00/68298; Hong, Y. *et al* Polymer 2000, 41, 7705.)

3      [0004] Arborescent polymers are further characterized by the absence of cross-links  
4      among the branches. In contrast to dendrimers that use monomers as building blocks,  
5      arborescent polymers usually are assembled from linear polymer chains. The synthesis of  
6      arborescent polymers therefore requires fewer steps to achieve a high molecular weight,  
7      which makes them more practical from the point of view of applications.

8      [0005] The majority of arborescent polymers are currently synthesized from vinyl  
9      monomers by anionic polymerization and grafting (Teetstra, S. and Gauthier, M. Prog.  
10     Polym. Sci. 2004, 29, 277). In this approach, a linear polymer is first synthesized,  
11     functionalized with coupling sites, and reacted with living anionic polymer chains. Different  
12     types of functional groups such as chloromethyl, and acetyl functionalities can be introduced  
13     onto the benzene ring of polystyrene in order to obtain coupling substrates. A range of  
14     'living' anionic polymers including polystyrene, poly(2-vinylpyridine), poly(*tert*-butyl  
15     methacrylate), and polyisoprene have been grafted onto polystyrene backbones to form  
16     arborescent homo- and copolymers. The synthesis of arborescent polymers by anionic  
17     polymerization and grafting, while more convenient than dendrimer syntheses, still requires  
18     multiple steps of substrate functionalization, polymerization, and grafting reactions.  
19     Furthermore, the coupling reaction is never complete, and linear polymer contaminant may  
20     need to be separated by fractionation before the synthesis of the next generation material.

21     [0006] Arborescent polymers are typically synthesized using cycles of substrate  
22     functionalization and anionic grafting reactions. Coupling sites are first introduced randomly  
23     on a linear substrate, and reacted with a 'living' polymer to yield a comb-branched or  
24     generation G0 arborescent polymer. Repetition of the functionalization and grafting cycles  
25     leads to upper generation (G1, G2...) arborescent polymers, with molecular weight and  
26     branching functionality increasing geometrically in successive generations if the branching  
27     density is maintained for successive generations. Both chloromethyl and acetyl functionalities  
28     have been used as coupling sites for the preparation of arborescent styrene homopolymers.  
29     Copolymers have also been obtained by grafting other macroanions onto arborescent  
30     polystyrene substrates.

31     [0007] Hempenius *et al* (Macromolecules 2001, 34, 8918) teach anionic grafting for the  
32     synthesis of arborescent butadiene homopolymers. Their method relies on the introduction of

1 coupling sites by exhaustive hydrosilylation of pendent vinyl units on a polybutadiene  
2 substrate with dimethylchlorosilane, followed by coupling with polybutadienyllithium.  
3 Unfortunately the chlorosilane derivative obtained is hydrolytically unstable, and has to be  
4 generated immediately before use. Another problem is that the 1,2-butadiene unit content of  
5 the substrate obtained in the polymerization reaction determines the branching density of the  
6 graft polymers.

7 [0008] At present, no methodology for the synthesis of arborescent isoprene homopolymers  
8 has been developed. Isoprene homopolymers have a wide range of physical properties and  
9 applications, and are rubbery in nature.

10 [0009] While the 'grafting onto' scheme, as described above, provides macromolecules  
11 with a narrow molecular weight distribution, it also depends on a large number of reaction  
12 steps.

13 [0010] In order to overcome the need for multi-step synthesis, attempts have been made  
14 to provide a one-pot methodology for synthesis of polymers displaying properties similar to  
15 dendrimers and arborescent polymers.

16 [0011] U.S. Patent No. 6,255,424 discloses a one-pot synthesis based on simultaneous  
17 anionic copolymerization and grafting reactions of styrene with either *p*-chloromethylstyrene  
18 or *p*-chlorodimethylsilylstyrene. As such the anionic propagating center at the focal point of  
19 the growing polymer, and the vinyl coupling sites on the branched polymer molecules adding  
20 to the focal point, is always sterically hindered by surrounding side chains. This steric  
21 hindrance limits the growth of the molecules and, therefore, it is very difficult to obtain a  
22 very high molecular weight polymer with a high branching density under these conditions.

23 [0012] In another methodology, (Baskaran, D. Polymer 2003, 44, 2213) self-condensing  
24 anionic copolymerization of styrene with *m*-diisopropenylbenzene is conducted in order to  
25 synthesize hyperbranched polystyrenes. The polymers obtained are characterized by  
26 multimodal molecular weight distributions. One-pot ATRP (atom transfer radical  
27 polymerization) copolymerization of styrene with *p*-chloromethylstyrene to generate side  
28 chains, combined with successive additions of ATRP catalyst was likewise investigated  
29 (Coskun, M. *et al.* J. Polym. Sci., Part A: Polym. Chem. 2003, 41, 668; Gaynor, S.G. *et al.*  
30 Macromolecules 1996, 29, 1079.) to synthesize arborescent polystyrenes. This approach is  
31 limited by the occurrence of cross-linking, and the difficulty in separating ATRP catalysts  
32 from the final products. Cationic copolymerization of isobutene with

1    *p*-methoxymethylstyrene, as sites used to generate side chains, in combination with  
2    successive additions of cationic catalysts, provided a one-pot method to synthesize  
3    arborescent polyisobutenes (Paulo, C. et al. *Macromolecules* 2001, 34, 734).

4    [0013]    It is an object of the present invention to obviate or mitigate at least some of the  
5    above mentioned disadvantages.

6    SUMMARY OF THE INVENTION

7    [0014]    A method for producing an arborescent polymer comprising the steps of:

- 8        a.      Epoxidizing a first polymer with an epoxidizing agent such that epoxide  
9                groups are chemically bonded to the first polymer at one or more sites; and,
- 10        b.      grafting a second polymer onto the epoxidized first polymer such that  
11                chemical bonds are formed between the first and second polymers so that the bond is formed  
12                at the epoxide groups,

13        wherein the second polymer includes reactive groups capable of forming bonds with the  
14                epoxide groups.

15    [0015]    In an additional embodiment the present invention provides a one-pot method of  
16        synthesizing arborescent polymers. Such method of the present invention includes the  
17        following steps in a single reaction pot:

- 18        1.      Copolymerization of a first polymer.
- 19        2.      The first polymer is reacted with an activating compound to generate reactive  
20                sites on the first polymer in order to produce a polyfunctional macroinitiator.
- 21        3.      Adding monomers having functional groups reactive towards the reactive sites  
22                on the first polymer, so that a bond is formed between the functional group and the  
23                reactive site.

24    [0016]    When a mixture of monovinyl and divinyl monomers is used in step 3, the grafted  
25        polymer generated by the above reaction may be subjected to a further cycle of activation and  
26        addition of monomers in order to grow side chains from the initiating sites.

27

28    BRIEF DESCRIPTION OF THE DRAWINGS

29    [0017]    These and other features of the preferred embodiments of the invention will  
30        become more apparent in the following detailed description in which reference is made to the  
31        appended drawings wherein:

- 1 [0018] Figure 1 depicts a reaction scheme for the synthesis of arborescent polyisoprene  
2 homopolymers.
- 3 [0019] Figure 2 presents  $^1\text{H}$  NMR spectra for the synthesis of sample G0: (a) linear  
4 polyisoprene substrate, (b) linear epoxidized polyisoprene substrate, and (c) fractionated graft  
5 polymer.
- 6 [0020] Figure 3 depicts SEC elution curves for the synthesis of linear arborescent  
7 polyisoprenes of successive generations.
- 8 [0021] Figure 4 depicts a preferred one-pot method reaction scheme.
- 9 [0022] Figure 5 depicts the reactivity of unsaturated species and propagation centers.
- 10 [0023] Figure 6 illustrates the influence of monomer addition rate and addition protocol  
11 on the molecular weight distribution of linear styrene-DIPB copolymers.
- 12 [0024] Figure 7 further illustrates the influence of monomer addition rate and addition  
13 protocol on the molecular weight distribution of linear styrene-DIPB copolymers.
- 14 [0025] Figure 8 illustrates the influence of polymerization time on the molecular weight  
15 distribution of G0 polymers.
- 16 [0026] Figure 9 compares SEC traces obtained for the one-pot synthesis of a linear  
17 substrate (L5), G0 substrate (G0-5b), and G1 polystyrene (G1-5b)
- 18

#### 19 DESCRIPTION OF THE PREFERRED EMBODIMENTS

- 20 [0027] The term 'living polymers' as used herein refers to polymers that have partly  
21 ionized end groups (or have ionic character) with which additional monomer units may react.
- 22 [0028] The term 'apparent polydispersity index' ( $M_w/M_n$ ) as defined herein is a measure  
23 of the uniformity of the population of polymers.  $M_w/M_n$  is calculated as the ratio of the  
24 apparent weight-average-average molecular weight ( $M_w$ ) of the polymers over the apparent  
25 number-average molecular weight ( $M_n$ ). The apparent  $M_w/M_n$  may be determined by size  
26 exclusion chromatography (SEC) analysis using a linear polystyrene standards calibration  
27 curve and a differential refractometer (DRI) detector.
- 28 [0029] The term 'grafting onto', as used herein, refers to a method of producing branched  
29 polymers in which functional groups on a first polymer are reacted with reactive sites on a  
30 second polymer, in order to chemically bond the second polymer onto the first polymer.

1 [0030] The term 'grafting from' as used herein refers to a method of producing reactive  
2 sites on a first polymer, followed by the addition of a monomer to the reactive sites in order  
3 to grow side chains from the reactive sites.

4 [0031] The term 'one-pot reaction', as used herein, refers to a method of producing  
5 arborescent polymers of successive generations by a sequence of reactions carried out  
6 sequentially in the same reactor (reaction pot), without isolation of products at any step.

7 **SYNTHESIS OF ARBORESCENT POLYMERS**

8 [0032] In one embodiment, the present invention provides a method of generating  
9 arborescent homopolymers or copolymers comprising the following steps:

- 10 1. Epoxidation of a first polymer, such that epoxide functional groups are introduced  
11 onto the polymer.
- 12 2. A second polymer, having sites reactive towards epoxide groups, is reacted with  
13 the first polymer such that a bond is formed between the sites on the second  
14 polymer and the epoxide groups.
- 15 3. The grafted polymer generated by the above reaction may be subjected to several  
16 cycles of epoxidation and grafting in order to produce arborescent polymers of  
17 higher generations.

18 [0033] The first polymer is the core polymer to which other polymer molecules will be  
19 anionically grafted onto in the method of the present invention. Examples of a first polymer  
20 include, but are not limited to, polyisoprenes of different microstructures, polybutadienes of  
21 different microstructures, and other polydienes of different microstructures. The first  
22 polymer may be a homopolymer or a copolymer, and may be in linear, branched or dendritic  
23 form.

24 [0034] The first polymer may be generated by polymerization methods that are well  
25 known in the art. For example, the first polymer may be generated by anionic or cationic  
26 polymerization of unsaturated monomers. The first polymer may also be generated by other  
27 techniques known in the art for the generation of linear, branched or dendritic polymers.  
28 Following generation of the first polymer, it may be purified from non-reacted monomers and  
29 other excipients. The polymer may then be analyzed for uniformity of length and  
30 composition.

31 [0035] The first polymer is epoxidized to chemically bond epoxide groups along its  
32 length.

1      Epoxidation of the first polymer is facilitated by the oxidation of alkene groups by peroxy  
2      compounds. In a preferred embodiment, in situ generated performic acid is used to generate  
3      the epoxidized first polymer of the present invention. An individual skilled in the art will  
4      recognize other peroxy compounds that can be used to epoxidize the first polymer.

5      [0036]     The epoxidation of alkenes by peroxy compounds is an electrophilic reaction  
6      mainly controlled by the electron density of the double bond. Alkyl substituents increase the  
7      electron density of the double bond and hence its reactivity. The reaction order for substituted  
8      alkenes toward epoxidation therefore decreases in the order tetra- > tri- > di- > mono- >  
9      unsubstituted.

10     [0037]    The first polymer can be characterized by 1 to 50 mol % epoxidation. In a  
11     preferred embodiment, the first polymer is characterized by 20-30 mol% epoxidation, or 20-  
12     30 % of the subunits in the polymer will bear an epoxide group. The degree to which the first  
13     polymer is epoxidized will be proportional to the number of branches that can be grafted onto  
14     the first polymer, within certain limitations. In reactions involving first polymers that are  
15     heavily epoxidized, not all the epoxide groups may be accessible to react due to steric  
16     hindrance. The degree of epoxidation of the first polymer may be controlled by varying the  
17     concentration of the epoxidizing agent that is being used, by varying the reaction times, or by  
18     methods that would be obvious to individuals of skill in the art.

19     [0038]    The degree to which the first polymer is epoxidized may be determined by  $^1\text{H}$   
20     NMR spectroscopy, for example, by comparing the  $^1\text{H}$  NMR spectrum of the epoxidized first  
21     polymer to that of the un-epoxidized first polymer. Other methods to determine the degree of  
22     epoxidation will be obvious to those of skill in the art.

23     [0039]    The second polymer is the polymer that will be grafted onto the first polymer.  
24     The second polymer may be a homopolymer or copolymer, and may be linear, branched, or  
25     dendritic, although linear is preferred. The second polymer includes reactive groups which  
26     form chemical bonds with the epoxide groups of the first polymer. In a preferred  
27     embodiment, second polymers are living polymers having an anionic reactive group. In a  
28     preferred embodiment, the second polymer has a single reactive site. In a preferred  
29     embodiment, the reactive site is located at a terminal position on the second polymer.  
30     Examples of a second polymer include, but are not limited to, polyisoprene, polystyrene, and  
31     substituted polystyrenes.

1 [0040] The second polymer may be reacted with a capping agent. Capping agents are  
2 molecules that chemically bind to the anionic terminal group and together with the terminal  
3 group, form the reactive site on the second polymer. Second polymers with capping agents  
4 are therefore less likely to undergo side reactions. Preferred capping agents are relatively  
5 small in order to avoid steric hindrance which may decrease the efficiency of the grafting  
6 reaction. An example of an appropriate capping agent is a capping agent derived from  
7 isoprene. Individuals of skill in the art will recognize other capping agents that may be used.

8 [0041] **Generation of the G0 Polymer.**

9 [0042] The G0 polymer is the product generated by one cycle of epoxidation of the first  
10 polymer and grafting of the second polymer. Typically, if the first polymer and the second  
11 polymer are linear, the G0 polymer will have a branched or comb structure. To generate the  
12 G0 polymer, the first polymer and the second polymer are combined in a suitable solvent  
13 under conditions that allow the reactive group on the second polymer to form a bond with  
14 epoxide groups on the first polymer.

15 [0043] The second polymer may undergo undesired side reactions wherein the anionic  
16 reactive group becomes neutralized.

17 [0044] To decrease the incidence of side reactions, promoters may be used to promote the  
18 coupling reaction between the epoxidized first polymer and the second polymer. Three  
19 distinct approaches can be used to influence the course of the reaction. Firstly, a Lewis base,  
20 such as *N,N,N',N'*-tetramethylethylenediamine (TMEDA), may be added to complex with the  
21 lithium counterion and increase the nucleophilicity of the polyisoprenyl anions. Secondly,  
22 Lewis acids can serve to increase the reactivity of the epoxide ring via coordination. Finally,  
23 lithium salts decrease the reactivity of the polyisoprenyl anions by a common ion effect but  
24 also increase the reactivity of the epoxide ring via coordination.

25 [0045] Examples of such promoters include, but are not limited to: TMEDA, boron  
26 trifluoride, trimethylaluminum, LiCl, or LiBr.

27 [0046] Lithium salts, such as LiCl or LiBr, are most effective as promoters, increasing the  
28 grafting yield from 78% to 92% for a linear substrate. Lithium ions suppress the anionic  
29 charge of the second polymer. By decreasing the incidence of side reactions the second  
30 polymers maintain their anionic charge and are therefore available to react with the epoxide  
31 groups of the first polymer.

1 [0047] Although not essential, the progress of the reaction between the polymers, and the  
2 degree to which the polymers have reacted may be monitored. In one embodiment, samples  
3 are removed from the grafting reaction and are analyzed by size exclusion chromatography  
4 (SEC). Unreacted polymer will be detected as relatively low molecular weight species  
5 compared to the graft polymer. The results of such analysis may be used to monitor the  
6 progress of the reactions.

7 [0048] Under certain circumstances, not all the epoxide groups may be accessible for  
8 grafting due to steric hindrance. This may occur in particular if the first polymer is branched  
9 or dendritic and is heavily epoxidized. Also, in certain circumstances, G0 polymers may be  
10 generated in which only a fraction of the epoxide groups are reacted with the second polymer.  
11 For example, the remaining epoxide groups may be reacted with another molecular species.  
12 For these reactions, the amount of the second polymer to be added may also be calculated  
13 knowing the degree of epoxidation of the first polymer.

14 [0049] Upon completion of the grafting reaction, the branched G0 polymer may be  
15 purified and analyzed. The form of the G0 polymer is determined by the structure of the first  
16 polymer and the second polymer.

17 [0050] **The Generation of G1 and G2 Polymers**

18 [0051] The G0 polymer may be used as a substrate for another cycle of epoxidation and  
19 grafting. For example, the G0 polymer may be epoxidized and a second polymer is reacted  
20 with the G0 polymer under similar grafting conditions as described previously. The reaction  
21 produces a G1 polymer wherein the branches have sub-branches. The degree of branching of  
22 the G1 polymer will be proportional to the degree to which the G0 polymer is epoxidized,  
23 within certain limitations described below. The second polymer may be added to the G0  
24 polymer in a stoichiometric amount. In another embodiment, an excess of epoxide  
25 functionalities on the G0 polymer is used relative to the second polymer in order to maximize  
26 the grafting yield.

27 [0052] Repeating the epoxidizing/grafting cycle using the G1 molecule as a substrate  
28 will generate a more highly branched G2 molecule. The number of branches increases with  
29 each generation, epoxide groups that are on the core polymer or on branches near the core  
30 polymer may not be accessible to grafting due to steric hindrance. This may result in a  
31 decrease in the grafting efficiency or the number of second polymers that may react with a  
32 given number of epoxide groups. In reactions wherein the G0 and G1 polymers are generated

1 with linear second polymers, reactions to generate further generations require 30-50% less  
2 second polymer compared to the number of epoxide sites on the polymer. As previously  
3 described, progress of the grafting reaction may be monitored by SEC.

4 [0053] In one embodiment, as described by example further below, linear polyisoprene is  
5 epoxidized and reacted with polyisoprenyllithium. More specifically, a linear polyisoprene  
6 substrate with a high (95%) 1,4-microstructure content is first epoxidized to introduce  
7 grafting sites randomly along the chain. Although a linear polyisoprene with a high *cis*-1,4-  
8 microstructure content was used in this embodiment, an individual of skill in the art will  
9 recognize that polymers having other microstructures may be used. For example, a polymer  
10 having a mixed microstructure with equal proportions of 1,2-, 1,4-, and 1,3- units.

11 [0054] Figure 1 depicts the coupling reaction utilized for an example of the method of the  
12 present invention, the preparation of arborescent polyisoprenes. A linear polyisoprene is first  
13 functionalized by partial epoxidation to introduce grafting sites randomly along the polymer  
14 chain. The epoxidized substrate, upon reaction with polyisoprenyllithium, yields a comb-  
15 branched (G0) isoprene homopolymer. As mentioned above, different promoters may be  
16 used to increase the rate and yield of the coupling reaction. The G0 polymer may be  
17 subjected to additional epoxidation and grafting cycles to generate upper generation  
18 arborescent polymers under the same conditions.

19 [0055] Further epoxidation and grafting of the G0 polyisoprene leads to arborescent  
20 isoprene homopolymers of generations G1 and G2. The graft polymers can be purified by  
21 fractionation and characterized by SEC, light scattering, and NMR spectroscopy.

## 22 ONE-POT SYNTHESIS OF ARBORESCENT POLYMERS

23 [0056] In an additional embodiment, the present invention provides a one-pot method of  
24 synthesizing arborescent polymers. In such method, a 'grafting from' scheme is utilized that  
25 allows the synthesis of consecutive generations of polymers from one single reaction pot.  
26 The one-pot approach of the present invention can be used to prepare homopolymers and  
27 copolymers.

28 [0057] Generally, the method of the present invention includes the following steps in a  
29 single reaction pot:

- 30 1. Copolymerization of a first polymer.
- 31 2. The first polymer is reacted with an activating compound to generate reactive  
32 sites on the first polymer in order to produce a polyfunctional macroinitiator.

1           3. Adding monomers having functional groups reactive towards the reactive sites  
2           on the first polymer, so that a bond is formed between the functional group and the  
3           reactive site.

4 [0058] When a mixture of monovinyl and divinyl monomers is used in step 3, the grafted  
5 polymer generated by the above reaction may be subjected to a further cycle of activation and  
6 addition of monomers in order to grow side chains from the initiating sites.

7 [0059] The first polymer is the core polymer to which monomers will be added in the  
8 'grafted from' approach described further below. The first polymer is a linear, or mostly  
9 linear polymer having unsaturated sites which may be reacted with an activating compound  
10 in order to generate reactive initiating sites. Monomers may then be reacted with the reactive  
11 sites of the first polymer. The first polymer may also be branched, wherein linear polymers  
12 are attached to a linear core polymer, or dendritic wherein the polymers forming the branches  
13 have polymer branches attached to them.

14 [0060] The first polymer may be generated by polymerization of the appropriate  
15 monomers by methods known in the art, for example, anionic polymerization of alkene  
16 monomers. In a preferred embodiment, the first polymer is obtained by copolymerization of  
17 a monovinyl monomer and a divinyl monomer in order to produce a mostly linear molecule.  
18 The term "mostly" linear is used because, during copolymerization of the first polymer, side  
19 reactions may occur which produce "dimers", wherein two chains of the polymer are linked  
20 together at random points along the chain. Following the generation of the first polymer, it  
21 may be purified from non-reacted monomers and other excipients.

22 [0061] In a preferred embodiment, the first polymer is a linear copolymer, most  
23 preferably, the first polymer is a mostly linear styrene and 1,3-diisopropenylbenzene (DIPB)  
24 copolymer or a mostly linear styrene and 1,4-diisopropenylbenzene copolymer. The  
25 synthesis of the styrene and 1,3-diisopropenylbenzene (DIPB) copolymer may be  
26 accomplished through methods that are known in the art. A reaction scheme depicting the  
27 synthesis of the preferred first polymer is provided in Figure 4. Due to the significant  
28 reactivity difference between styrene and DIPB, control over the monomer addition rate  
29 during synthesis of the copolymer may be needed to achieve a relatively random distribution  
30 of DIPB units in the styrene-DIPB copolymer, while preventing reaction of the second  
31 isopropenyl group.

1 [0062] After initiation, three types of propagating centers and three types of unsaturated  
2 species are present in the reaction depicted in Figure 5. The reaction is therefore best  
3 described as a terpolymerization reaction. In Figure 5, among the three propagating species,  
4 the double bonds in 2 and 3 have increased steric hindrance, and therefore a lower reactivity  
5 than 1. In compounds 2 and 3 the isopropenyl group is weakly electron-withdrawing, but  
6 converted to an alkyl functionality after polymerization, becoming electron-donating.  
7 Furthermore, because of increased steric hindrance from the polymer chain in the *meta*-  
8 position, compound 3 has a lower reactivity than 2. The lower reactivity of pendent  
9 isopropenyl groups was also pointed out in DIPB homopolymerization and its  
10 copolymerization with  $\alpha$ -methylstyrene (Lutz, P. *et al.* Am. Chem. Soc. Div. Polym. Chem.  
11 Polym. Prepr. 1979, 20, 22). Similarly, since 5 and 6 have increased steric hindrance, their  
12 reactivity should be somewhat lower than 4. The reactivity difference can be confirmed from  
13 the color changes observed when adding the styrene-DIPB monomer mixture to the reactor.  
14 Styrene polymerizes first to give a yellow color initially. After styrene is consumed, DIPB  
15 polymerizes predominantly to give a dark brown color. Ideally monomers 1 and 2 should  
16 copolymerize randomly, to full conversion, and without any reaction of species 3. If the  
17 conversion of DIPB is incomplete, both double bonds of the unreacted monomer are activated  
18 upon addition of *sec*-BuLi in the synthesis of next generation graft polymer, leading to the  
19 formation of linear polymer contaminant. The reaction of 3 leads to dimerization or cross-  
20 linking. To minimize the occurrence of these problems the reaction temperature, monomer  
21 ratio, concentration, monomer addition protocol, and reaction time (after monomer addition)  
22 need to be optimized.

23 [0063] In the method of the present invention, the first polymer is reacted in the reaction  
24 pot with an appropriate activating compound to generate reactive sites for the ‘grafting from’  
25 of monomer units. The activating compound is a compound that can react with unsaturated  
26 sites on the first polymer, in order to generate a polyfunctional macroinitiator. An example  
27 of an activating compound that may be used in the process of the present invention is an  
28 organometallic compound including but not limited to, *n*-butyllithium or *tert*-butyllithium. In  
29 a preferred embodiment, the activating compound is *sec*-butyllithium.

30 [0064] In a preferred embodiment, the first polymer is dissolved in a solvent, such as  
31 cyclohexane or toluene, and is reacted with an organometallic compound. It will be evident

1 to those skilled in the art, that a number of solvents, reaction temperatures, and activating  
2 compounds may be used without departing from the scope of the invention.

3 [0065] Figure 4 also depicts the activation of reactive sites on the preferred copolymer  
4 through reaction with *sec*-butyllithium.

5 [0001] In the one-pot method of the present invention, monomers are added to the  
6 reaction pot subsequent to the activation of reactive sites on the first polymer. The monomers  
7 react with the activated reactive sites of the first polymer and are chemically bonded to the  
8 first polymer. Monomers that may be utilized in the method of the present invention are  
9 anionically polymerizable monomers including, but not limited to, styrene, dienes,  
10 vinylpyridines, alkyl acrylates, alkyl methacrylates, ethylene oxide,  
11 hexamethylcyclotrisiloxane, and  $\epsilon$ -caprolactone. An individual of skill in the art will  
12 recognize other monomers which could be utilized in the present method. The addition of  
13 monomer units to an activated first polymer yields a polymer of generation G0. The G0  
14 polymer may have, for example, a comb-branched structure. Figure 4 illustrates the addition  
15 of styrene and DIPB monomers to the preferred styrene-DIPB copolymer in order to yield a  
16 G0 styrene-DIPB copolymer.

17 [0067] In the preferred embodiment, further reaction of the G0 styrene-DIPB copolymer  
18 with an activating compound generates a G0 polyfunctional anionic macroinitiator that can  
19 serve to produce G1 arborescent polymers with a dendritic structure. The G0 polymer reacts  
20 with the activating compound to produce reactive sites on the G0 polymer. Monomers are  
21 then added to the reaction pot subsequent to the activation of reactive sites on the G0  
22 polymer. The monomers react with the activated reactive sites of the G0 polymer and are  
23 chemically bonded to the polymer.

24 [0068] The length (molecular weight) of the side chains generated during each 'grafting  
25 from' cycle can be controlled by varying the amount of monomer added to the macroinitiator  
26 at each step.

27 [0069] The cycle of activating of reactive sites by an activating compound and addition  
28 of monomer units may be repeated to generate molecules of higher generations. Cycling may  
29 continue until the polymer has achieved a desired size, however the efficiency of monomer  
30 addition will decrease due to steric hindrance. In a preferred embodiment, the cycling is  
31 stopped after formation of a G1 polymer due to an increasing probability of side reactions.

1   Figure 4 illustrates the addition of monomers to a G0 styrene-DIPB copolymer in order to  
2   produce a G1 copolymer.

3   [0070]   In one embodiment, the monomer polymerization may be terminated shortly after  
4   addition of monomer units in order to prevent cross-linking between chains. Another strategy  
5   that may be used to avoid cross-linking is to use an excess amount of organometallic  
6   compound in the activation reaction.

7   [0071]   Because the active centers are always located at the chain ends of the last chains  
8   grown, it is possible to add sequentially different monomers of comparable or increasing  
9   reactivity to obtain arborescent molecules with block copolymer side chains, for example.  
10   Monomers in the sequence styrene/isoprene, 2-vinylpyridine, acrylates/methacrylates could  
11   thus be added to synthesize branched molecules with homopolymer or block copolymer side  
12   chains and a wide variety of physical properties. The synthesis of grafted G0 and G1  
13   polystyrene-*block*-poly(2-vinylpyridine) copolymers was achieved to illustrate this concept,  
14   as described by example below.

15   [0072]   The monomer ratio used in the copolymerization reaction determines the  
16   branching density of the graft polymers. For example, in a preferred embodiment wherein  
17   the first polymer is a styrene-DIPB copolymer, to obtain compact molecules, a significant  
18   mole fraction (e.g., 20-30%) of pendent isopropenyl groups should be present within the  
19   chains. The monomer ratio also influences the extent of side reactions leading to  
20   dimerization. In the preferred embodiment, a high styrene content in the mixture should  
21   increase the probability of pendent isopropenyl group attack and dimerization. Conversely, at  
22   low styrene/DIPB ratios it may take a longer time for DIPB to polymerize, also increasing the  
23   cross-linking probability. Analysis results by gas chromatography confirmed that for a  
24   styrene/DIPB ratio of 2.5, it took a longer time for DIPB to reach a high conversion. Another  
25   problem is that when the density of pendent isopropenyl groups is high a significant number  
26   of sites may not be activated, thus favoring cross-linking in the subsequent reaction step (e.g.,  
27   after addition of pure styrene monomer) because of the high reactivity of the anions  
28   generated. A relatively narrow molecular weight distribution is obtained for a styrene/DIPB  
29   ratio between 2.5-3, presumably due to decreased cross-linking probability.

30   [0073]   To decrease the incidence of side reactions, additives may be used to control the  
31   reaction between, for example, monomers and the first polymer, or monomers and the G0  
32   polymer. LiCl and lithium alcoholates are widely used to modify the reactivity of anionic

1 propagating centers when lithium is the counterion (Huyskens, P.L., *et al.* J. Molecular  
2 Liquids, 1998, 78, 151). Lithium salts, for example, may be added, if desired, in the present  
3 method in order to increase the efficiency of reactions.

4 [0074] The one-pot method of the present invention can be used to synthesize copolymers  
5 combining hydrophobic and hydrophilic chain segments.

6 [0075] The association of anionic ‘living’ polymers in medium- to low-polarity solvents  
7 is known to lead to decreased chain end reactivity (Roovers, J.E. *et al.* Can. J. Chem. 1968,  
8 46, 2711). In a preferred embodiment, in which the first polymer is a styrene-DIPB  
9 copolymer, the use of solvents such as toluene or cyclohexane under ambient conditions may  
10 be beneficial by minimizing the attack of pendent isopropenyl moieties by the polystyryl  
11 anions. Another potential advantage of this approach is that unlike THF, these solvents are  
12 inert towards organolithium compounds and cannot cause chain end deactivation in the  
13 synthesis of the styrene-DIPB copolymers.

14 [0076] Although not essential, the polymers generated by the method of the present  
15 invention may be characterized using methods known in the art. For example, size exclusion  
16 chromatography (SEC) analysis may be used to determine the apparent molecular weight of  
17 graft polymer samples. In addition, absolute weight-average molecular weight ( $M_w$ ) of the  
18 graft polymers may be determined from either batch-wise light scattering measurement in  
19 toluene or THF or on a SEC system coupled with a multi-angle laser light scattering  
20 (MALLS) detector in THF. Other methods of characterizing the polymers produced by the  
21 method of the present invention will be evident to an individual skilled in the art.

22 **A) SYNTHESIS BASED ON EPOXIDATION**

23 [0077] **Example #1: Solvent and reagent purification**

24 [0078] Hexane (BDH, mixture of isomers, HPLC Grade) was purified by refluxing with  
25 oligostyryllithium under nitrogen, and introduced directly from the still into the  
26 polymerization reactor through polytetrafluoroethylene (PTFE) tubing. Tetrahydrofuran  
27 (THF, Caledon, reagent grade) was refluxed and distilled from sodium-benzophenone ketyl  
28 under nitrogen. Isoprene (Aldrich, 99%) was first distilled from CaH<sub>2</sub>, and further purified  
29 immediately before polymerization by addition of *n*-butyllithium (Aldrich, 2.0 M solution in  
30 hexane; 1 mL solution per 20 mL isoprene) and degassing with three freezing-evacuation-  
31 thawing cycles, before recondensation into an ampule with a PTFE stopcock. Monomer  
32 ampules were stored at -78 °C before use. Boron trifluoride diethyl etherate (Aldrich,

1 redistilled) was distilled twice before use. *N,N,N',N'*-tetramethylethylenediamine (TMEDA)  
2 was first distilled from CaH<sub>2</sub>, and then from *n*-butyllithium. The initiator *t*-butyllithium (*t*-  
3 BuLi, Aldrich, 1.7 M solution in pentane) was used as received; its exact concentration was  
4 determined to be 1.9 M by the method of Lipton *et al* (J. Organomet. Chem. 1980, 186, 155.)  
5 2,2'-Bipyridyl (Aldrich, 99+%) was dissolved in purified hexane to give a 0.01 M solution.  
6 Lithium chloride (Aldrich, 99.9%), lithium bromide (Aldrich, 99+%), trimethylaluminum  
7 (Aldrich, 2.0 M solution in toluene), toluene (BDH, HPLC grade), hydrogen peroxide (BDH,  
8 29-32%), and formic acid (BDH, 96%) were used as received from the suppliers.

9 [0079] **Example #2: Isoprene Polymerization**

10 [0080] An isoprene monomer ampule (30.0 g, 0.441 mol), the hexane line from the  
11 purification still, and a rubber septum were mounted on a four-neck 500-mL round-bottomed  
12 flask with a magnetic stirring bar. The flask was flamed under high vacuum and filled with  
13 purified nitrogen. Hexane (100 mL) was added to the flask, followed by 0.5 mL  
14 2,2'-bipyridyl solution and the solvent was titrated with *t*-BuLi to give a persistent light  
15 orange color. The initiator (3.2 mL, 6.0 mmol *t*-BuLi, for a calculated M<sub>n</sub> = 5000) was  
16 injected in the reactor, and isoprene was added drop-wise from the ampule. The flask was  
17 maintained in a water bath at room temperature (23-25 °C) for 5 h, and the reaction was  
18 terminated with nitrogen-purged methanol. The crude product (29.5 g) was recovered by  
19 precipitation in 2-propanol and drying under vacuum for 24 h. The polymer, analyzed by  
20 SEC, had a polystyrene-equivalent (apparent) M<sub>w</sub> = 5800, an absolute M<sub>w</sub> = 5400 (M<sub>w</sub>/M<sub>n</sub> =  
21 1.06) as determined by SEC using a multi-angle laser light scattering (MALLS) detector, and  
22 a microstructure with 70% *cis*-1,4-, 25% *trans*-1,4- and 5% 3,4-units as determined by <sup>1</sup>H  
23 NMR spectroscopy.

24 [0081] For the polymerization of isoprene in non-polar solvents, a predominantly *cis*-1,4-  
25 microstructure resembling natural rubber is obtained, while chain end isomerization in polar  
26 solvents (such as THF) leads to a mixed microstructure with approximately equal proportions  
27 of 1,4-, 1,2- and 3,4- microstructures. In non-polar (hydrocarbon) solvents, the *cis*-1,4-  
28 content increases when the initiator concentration is decreased or the monomer concentration  
29 is increased.

30 [0082] **Example #3: Epoxidation of Polyisoprene**

31 [0083] The epoxidation of the linear polyisoprene substrate is provided as an example.  
32 Toluene (200 mL), polyisoprene (10.0 g, 0.147 equiv isoprene units) and formic acid (7.50 g,

1 0.156 mol) were combined in a 500-mL jacketed round-bottomed flask with a magnetic  
2 stirring bar. The flask was heated to 40 °C with a circulating water bath and the H<sub>2</sub>O<sub>2</sub> solution  
3 (17.7 g, 0.163 mol) was added drop-wise with stirring over 20 min. The reaction was  
4 continued at 40 °C for 50 min. The organic phase was washed with water until the aqueous  
5 layer reached pH 7. The polymer (10.3 g) was precipitated in methanol and dried under  
6 vacuum for 24 h. The epoxidation level of the sample determined by <sup>1</sup>H NMR analysis was  
7 26 mol%.

8 [0084] **Example #4: Grafting Reaction**

9 [0085] The preparation of a G0 (comb-branched) polyisoprene using optimized reaction  
10 conditions is described as an example of graft polymer synthesis using the method of the  
11 present invention. The linear epoxidized polyisoprene substrate (1.90 g, 7.0 equiv epoxide  
12 units) was purified with three azeotropic drying cycles (Li, J. and Gauthier, M.  
13 Macromolecules 2001, 34, 8918; Gauthier, M. and Möller, M., Macromolecules 1991, 24,  
14 4548) in an ampule using THF before redissolution in 100 mL dry THF. A four-neck 500-mL  
15 round-bottomed flask with a magnetic stirring bar was set up with an isoprene ampule  
16 (28.0 g, 0.412 mol), the epoxidized substrate ampule, the dry hexane inlet, and a septum. The  
17 isoprene was polymerized with 3.0 mL *t*-BuLi solution (5.6 mmol, for a target M<sub>n</sub> = 5000) in  
18 50 mL hexane as described above. After 5 h a sample was removed and terminated with  
19 methanol, to determine the side chain molecular weight. The substrate solution was added to  
20 the flask and the grafting reaction was allowed to proceed for 60 h at room temperature.  
21 Sample aliquots were removed by syringe every 6h and terminated with degassed methanol  
22 to monitor the progress of the reaction. Residual macroanions were terminated with degassed  
23 water, and the crude product (28.1g) was recovered by precipitation in methanol and dried  
24 under vacuum. The crude graft polymer was purified by precipitation fractionation from  
25 hexane/2-propanol mixtures, to remove the linear polyisoprene contaminant. The  
26 fractionated G0 polymer was further epoxidized and grafted by the same procedures  
27 described to yield upper generation polymers.

28 [0086] G1 and G2 arborescent polyisoprenes were prepared using the same techniques  
29 described for the synthesis of the G0 polymer.

30 [0087] The experimental results obtained for the synthesis of G0-G2 arborescent  
31 polyisoprenes using the optimized reaction conditions with high *cis*-1,4-polyisoprene side  
32 chains are summarized in Table 1. A living end to epoxide ratio of 0.9 and 6 equiv LiBr were

1 added to all reactions. Under these conditions, the grafting yields typically ranged from 91%  
2 for the G0 polymer (grafting onto a linear substrate) to 76% for the G2 product (grafting onto  
3 a G1 substrate).

4 [0088] Size exclusion chromatography served to determine apparent molecular weights  
5 and molecular weight distributions for the side chain and graft polymer samples. The  
6 instrument, operated at 25 °C, consists of a Waters 510 HPLC pump, a 500 mm × 10 mm  
7 Jordi DVB Mixed-Bed Linear column (molecular weight range 10<sup>2</sup>-10<sup>7</sup>), and a Waters 410  
8 differential refractometer (DRI) detector. THF at a flow rate of 1 mL/min served as eluent  
9 and linear polystyrene standards were used to calibrate the instrument.

10 [0089] The absolute weight-average molecular weight of the graft polymers was  
11 determined in heptane at 25 °C from light scattering measurements using a Brookhaven BI-  
12 200 SM light scattering goniometer equipped with a Lexel 2-W argon ion laser operating at  
13 514.5 nm. A series of 6-8 solutions with linear concentration increments were measured at  
14 angles ranging from 30-145°. The M<sub>w</sub> was determined by Zimm extrapolation to zero  
15 concentration and angle. The refractive index increment ( $dn/dc$ ) values used in the  
16 calculations were measured at 25 °C on a Brice-Phoenix differential refractometer equipped  
17 with a 510 nm band-pass interference filter.

18 [0090] <sup>1</sup>H NMR spectra were acquired for the polyisoprene, epoxidized polyisoprene, and  
19 graft polyisoprene samples on a Bruker-300 instrument in CDCl<sub>3</sub>.

20 [0091] <sup>1</sup>H NMR spectra for the purified G0 polymer (curve c), linear polyisoprene (curve  
21 a) and linear epoxidized polyisoprene (curve b) are compared in Figure 2. The G0, G1, and  
22 G2 arborescent polyisoprenes have NMR spectra very similar to linear polyisoprene.

23 [0092] A series of SEC elution curves are provided in Figure 3 for the synthesis of the G0  
24 arborescent polyisoprene sample (curves a-d) and for the G1 and G2 purified graft polymers.  
25 Reaction of the polyisoprenyl anions (curve a) with the linear epoxidized polyisoprene  
26 substrate (curve b) yield a crude product (curve c) consisting of the coupling product  
27 (leftmost peak) and nongrafted polyisoprene side chains (rightmost peak). The grafting  
28 efficiency can be estimated from the SEC peak area. If the area of the graft polymer peak is  
29 defined as A1, and the area obtained for the non-grafted side chains A2, the grafting  
30 efficiency is approximated as A1/(A1+A2) × 100%. The linear contaminant is easily  
31 removed from the crude product by fractionation (curve d), as well as from the G1 and G2

1 arborescent polymers (curves e-f). The apparent (polystyrene equivalent)  $M_w$  of the graft  
 2 polymers, determined by SEC analysis using a differential refractometer (DRI) detector,  
 3 ranges from  $4.6 \times 10^4$  (G0) to  $8.8 \times 10^5$  (G2), as indicated in Table 1. The absolute  $M_w$  of the  
 4 same polymers, using light scattering, range from  $8.7 \times 10^4$  (G0) to  $1.0 \times 10^7$  (G2). The large  
 5 (up to 10-fold) underestimation of  $M_w$  by SEC analysis with a DRI detector is clearly the  
 6 result of the very compact structure of arborescent isoprene homopolymers, in analogy to  
 7 former observations in various arborescent systems.

8 **Table 1. Synthesis of higher generation graft polymers<sup>a</sup>**

Gen	Hexane : THF / mL : mL	$M_w^{br}$ <sup>b</sup> / 10 <sup>3</sup>	Time / h	PDI	Yield / %	$M_w / 10^3$		$f_w$ <sup>e</sup> / %	$C_e$ <sup>f</sup> / %
						SEC <sup>c</sup>	LS <sup>d</sup>		
G0	50 : 100	5.3	60	1.04	91	46	87	15	84
G1	50 : 150	5.4	72	1.04	83	300	1100	180	54
G2	50 : 200	5.5	75	1.05	76	880	10000	1630	44

9 <sup>a</sup>All reactions using a side chain : epoxy group ratio = 0.9, LiBr : living end = 6, at 25 °C;<sup>b</sup>  
 10 Absolute molecular weight of side chains; <sup>c</sup>Apparent molecular weight from SEC analysis  
 11 using a differential refractometer detector and a linear polystyrene standards calibration  
 12 curve; <sup>d</sup>Absolute molecular weight from light scattering; <sup>e</sup>Number of side chains added in  
 13 the last grafting reaction; <sup>f</sup>Coupling efficiency.

14 [0093] The branching functionality of the graft polymers, also reported in Table 1, was  
 15 calculated from the equation

$$16 f_w = \frac{M_w(G) - M_w(G-1)}{M_w^{br}} \quad (1)$$

17 where  $M_w(G)$ ,  $M_w(G-1)$ , and  $M_w^{br}$  are the absolute molecular weights of polymers of  
 18 generation G, of the previous generation, and of the side chains, respectively. It corresponds  
 19 to the number of side chains added in the last grafting reaction.

20 [0094] The coupling efficiency ( $C_e$ ), defined as the fraction (percentage) of epoxy  
 21 coupling sites becoming linked to side chains, can be calculated as the ratio of  $f_w$  to the  
 22 number of coupling sites on the substrate, or alternatively from the equivalent equation:

1

$$C_e = \frac{f_w \cdot M_M}{M_w(G-1) \cdot E} \times 100 \quad (2)$$

2 where  $M_M$  is the molecular weight of isoprene (68.1),  $E$  is the epoxidation level of the  
3 substrate polymer, and  $G_e$  is grafting yield. The coupling efficiencies calculated based on the  
4 MALLS results are provided in Table 1. The decrease in coupling efficiencies observed from  
5 G0-G2 reflects the decreasing growth rates observed for higher molecular weight polymers.

6 **B) One-Pot Synthesis of Arborescent Polymers**

7 [0095] **Example #5: Solvent and Reagent Purification**

8 [0096] Toluene (BDH, HPLC grade) was purified by refluxing with oligostyryllithium  
9 under nitrogen, and introduced directly from the still into the reaction flask through  
10 polytetrafluoroethylene (PTFE) tubing. Tetrahydrofuran (THF, Caledon, reagent grade) was  
11 refluxed and distilled from sodium-benzophenone ketyl under nitrogen. Styrene (Aldrich,  
12 99%) was first distilled from  $\text{CaH}_2$ , and further purified immediately before polymerization  
13 by addition of phenylmagnesium chloride (Aldrich, 2.5 M solution in THF; 1 mL solution per  
14 10 mL styrene) and degassing with three freezing-evacuation-thawing cycles before  
15 condensing into an ampule with a PTFE stopcock (Li, J. and Gauthier, M. *Macromolecules*,  
16 2001, 34, 8918) under high vacuum. For the synthesis of arborescent polystyrene, and  
17 copolymers with 2-vinylpyridine and *t*-butyl methacrylate with different side chain length  
18 and identical branching functionalities by the successive monomer additions method, styrene  
19 was diluted (1.0 g in 10 mL solution) with THF by condensing THF under high vacuum to  
20 the ampule. 1,3-Diisopropenylbenzene (DIPB, Aldrich, 97%) was distilled twice from  $\text{CaH}_2$ .  
21 1,4-Diisopropenylbenzene (1,4-DIPB) was synthesized by the Grignard reaction of  
22 dimethylterephthalate with  $\text{MeMgI}$  (Mitin, Y.V. *Zhurnal Obschei Khimii*, 1958, 28,3303;  
23 Lutz, P. *et al* *Eur. Polym. J.* 1979, 15, 1111) and purified by two successive distillations from  
24  $\text{CaH}_2$ . The DIPB and 1,4-DIPB monomers were finally purified by azeotropic drying with  
25 THF in an ampule before use, and purified styrene was added under nitrogen to obtain the  
26 required ratio in the monomer mixture. 2-Vinylpyridine (2VP, Aldrich, 97%) was first  
27 distilled from  $\text{CaH}_2$ , stirred again with  $\text{CaH}_2$  overnight, and recondensed into an ampule  
28 under vacuum after degassing with three freezing-evacuation-thawing cycles. The monomer  
29 was then diluted with THF (10 mL/g) by recondensation under vacuum. *t*-Butyl methacrylate  
30 (BMA, TCI America, 98%) was first distilled under vacuum after stirring over  $\text{CaH}_2$ .

1 overnight. It was further purified by degassing on a vacuum line, titration with a 1:1 mixture  
2 (v/v) of triethylaluminum (TEA, Aldrich, 1.9 M in toluene) and diisobutylaluminum hydride  
3 (DIBAH, Aldrich, 1.0 M in toluene) to a light greenish color, (Long, T.E. *et al.* In: Recent  
4 Advances in Mechanistic and Synthesis Aspects of Polymerization, M.; Guyot, A., Eds.;  
5 NATO ASI Ser. 1987, 215, 79.; Allen, R.D. *et al.* Polym. Bull. 1986, 15,127) and  
6 recondensation into an ampule under vacuum after degassing with three freezing-evacuation-  
7 thawing cycles, before dilution with THF (10 mL/g). After purification, all monomer ampules  
8 were stored at -78 °C (dry ice) before use. *N,N,N',N'*-tetramethylethylenediamine (TMEDA)  
9 was first distilled from CaH<sub>2</sub>, and then from *n*-butyllithium. *sec*-Butyllithium (*sec*-BuLi,  
10 Aldrich, 1.3 M solution in cyclohexane) was used as received; its exact concentration was  
11 determined to be 1.35 M by the method of Lipton *et al.* (J. Organomet. Chem. 1980, 186,  
12 155). Lithium chloride (Aldrich, 99.9%) was flamed under high vacuum in an ampule and  
13 dissolved with purified THF (by vacuum condensation) before use.

14 [0097] **Example #6: Synthesis of Linear styrene-DIPB Copolymer**

15 [0098] A 1-L five-neck round-bottomed flask with a magnetic stirring bar was mounted  
16 on a high vacuum line together with toluene and THF inlets from the purification stills, a  
17 LiCl ampule (1.40 g in 50.0 mL THF), and a rubber septum. The flask was flamed under high  
18 vacuum and filled with purified nitrogen. After cooling, toluene (20.0 mL) was added as well  
19 as 1 drop of styrene through a syringe. The solvent was titrated with *sec*-BuLi to give a  
20 persistent light yellow color. An aliquot of *sec*-BuLi (0.18 mL, 0.24 mmol) was then injected  
21 in the reactor, followed by 0.14 mL styrene (1.2 mmol, for a degree of polymerization DP =  
22 5). After 20 min, the flask was cooled to -78 °C and THF (40.0 mL) was added. After 10 min,  
23 1.40 g (1.54 mL) of a styrene-DIPB mixture (3:1 ratio mol:mol, for an average DP = 50) was  
24 injected from a gas-tight syringe (in 0.15 mL aliquots, followed by a 70-80 sec wait) over a  
25 period of 16 min, leading to color changes alternatively between yellow and brown. After  
26 addition of the monomer, the reaction was allowed to proceed at -78 °C with stirring for 1 h,  
27 while removing samples every 15 min for size exclusion chromatography (SEC) analysis.  
28 The reaction was then terminated by titration with a nitrogen-purged 10:1 THF-methanol  
29 mixture to just reach the (colorless) end point. A 30-mL aliquot of the polymer solution was  
30 removed through the septum, and the concentration of residual DIPB was determined on a  
31 Hewlett-Packard 5890 gas chromatograph. The copolymer (0.72 g, 95% yield) was recovered  
32 by precipitation in methanol, dried under vacuum for 24 h, and analyzed by SEC (apparent

1  $M_n = 7700$ ,  $M_w/M_n = 1.38$  based on a linear polystyrene calibration curve) and  $^1\text{H}$  NMR  
 2 spectroscopy. Further results for the synthesis of linear styrene-DIPB copolymers are  
 3 provided in Table 2.

4 **Table 2. Synthesis of linear styrene-DIPB copolymers<sup>a</sup>**

5

Sample	St:DIPB	Temp / °C	Monomer addition		Reaction time <sup>b</sup> / min	Polymer	
			Method	Time / min		$M_n^{\text{SEC}} / 10^3$	$M_w/M_n$
L1	3:1	-35	Dropwise	10	5	5.9	1.35
					30	6.4	1.46
					60	7.7	1.56
L2	3:1	-78	Dropwise	16	5	6.2	1.30
					30	6.9	1.34
					60	7.7	1.38
L3	3:1	-78	Dropwise	24	5	7.3	1.40
					30	7.5	1.43
					60	8.0	1.49
					120	9.3	1.69
L4	3:1	-78	Syringe pump	16	5	6.4	1.31
					30	6.9	1.38
					60	7.6	1.41
L5	3:1	-78	Semi-batch	13	5	6.8	1.27
					30	7.3	1.31
					60	7.5	1.32
L6	2.5:1	-78	Dropwise	16	5	6.1	1.41
					30	7.4	1.56
					60	7.8	1.62
L7	2.5:1	-78	Semi-batch	17	5	6.1	1.21
					30	7.4	1.32
					60	7.8	1.43
L8	3.5:1	-78	Semi-batch	12	5	6.3	1.35
					30	7.3	1.42

6

7 <sup>a</sup> DP = 5 oligostyryllithium as initiator, 50 equiv mixed monomer added for chain growth; <sup>b</sup>  
 8 Reaction time after monomer addition completed; L represents a linear copolymer, followed  
 9 by a number representing the run (attempt) number.

10 [0099] As discussed further above, styrene and DIPB display a significant reactivity  
 11 difference. If the monomer mixture is added too fast to the reaction, it will generate a tapered  
 12 block copolymer with a styrene-rich first block and a DIPB-rich second block. This may

cause two problems: First, DIPB would homopolymerize very slowly after styrene is consumed. Second, activation of the graft polymer obtained would be very difficult because part of the chain is very rich in DIPB. To synthesize a branched polymer with side chains more uniformly distributed along the backbone the monomer addition rate was decreased, to ensure significant monomer consumption before addition of the next monomer aliquot. On the other hand, polystyryl anions may also attack the pendent isopropenyl groups more readily than the polyDIPB anions. If the monomer mixture is added too slowly a higher average concentration of polystyryl anions may be present in the reaction, thus increasing the probability of attack of the pendent isopropenyl groups and favoring dimerization or cross-linking. In other words, slow monomer addition may favor a high DIPB conversion but also broaden the MWD.

[00100] It can be seen by comparing the results in Table 2 obtained for samples L2-L3 that a longer monomer addition time leads to higher number-average molecular weight ( $M_n$ ) and polydispersity index ( $M_w/M_n$ ) values. The influence of monomer addition time on the MWD is also shown in the SEC traces of Figure 6. Curves (b) and (c) were obtained for samples removed from the reactor 5 min after completing the monomer addition, for total monomer addition times of 16 min (sample L3) and 24 min (sample L2), respectively. It is clear that the peak molecular weight and the breadth of the MWD both increased for a fixed post-addition waiting time of 5 min. A larger amount of 'dimer' is formed in the reaction for longer monomer addition intervals, giving rise to a broader MWD. Because the rate of manual monomer addition may likely vary, a syringe pump was also used to add the monomer mixture at a more constant rate (sample L4). Comparison of the results obtained for samples L4 and L2 shows that the products are in fact comparable. Considering that both polystyryllithium and poly(1,3-diisopropenyl)lithium propagating centers are likely present at all times in the slow monomer addition protocol, and that polystyryllithium may attack pendent isopropenyl moieties to cause dimerization, semi-batch monomer addition protocols were also investigated. In the semi-batch protocol a waiting time follows every mixed monomer addition, so that styrene polymerizes predominantly first and the residual monomer forms a short DIPB-rich segment at the chain ends. Under these conditions most polymer chains should be eventually capped with DIPB, thus decreasing the probability of pendent isopropenyl group attack. For samples L6 and L7 in Table 2 and curve (a) for L5 in Figure 6,

1 it can be seen that semi-batch addition leads to shorter monomer addition time (determined  
2 by color change) and a narrower MWD.

3 [00101] Example #7: Synthesis of G0 (comb-branched) Styrene-DIPB copolymer

4 [00102] The 30-mL reaction mixture remaining in the flask after the synthesis of the linear  
5 copolymer (0.76 g polymer) was diluted to 300 mL with purified THF and cooled to -20 °C  
6 using an ice-methanol bath. The mixture was titrated with *sec*-BuLi to a light brown color,  
7 and 1.35 mmol *sec*-BuLi (1.0 mL, for 23% metalation of the substrate based on the monomer  
8 mixture used, 92% metalation based on DIPB units alone) was added to produce initiating  
9 sites along the linear polymer substrate. After 4 h, the reaction mixture was cooled to -78 °C,  
10 and 8.0 g styrene-DIPB (3:1 mol/mol) mixture (for a side chain DP = 50 units) was added  
11 slowly over a period of 30 min, producing color changes alternating between yellow and  
12 brown. After addition of the monomer mixture the reaction was continued for 1 h, and  
13 samples were removed from the reactor after 5 min and 30 min for SEC and GC analysis. The  
14 reaction was terminated by titration with a 10:1 THF-methanol mixture. Two-thirds (200 mL)  
15 of the reaction mixture was then removed from the reactor. The polymer (5.7 g, 97% yield)  
16 was recovered by precipitation into methanol, dried under vacuum for 24 h and analyzed by  
17 SEC (apparent  $M_w = 1.1 \times 10^5$ ,  $M_w/M_n = 1.78$ ), NMR and SEC-MALLS (multi-angle laser  
18 light scattering).

19 [00103] Further results for the synthesis of G0 styrene-DIPB copolymers are provided in  
20 Table 3.

1 [00104] **Table 3. Synthesis of G0 styrene-DIPB copolymers<sup>a</sup>**

Sample	St: DIPB	THF / mL	Monomer addition		Waiting time (min)	G0		Residual DIPB
			Method	Time / min		$M_w$ $/ 10^3$	$M_w/M_n$	
G0-1	3:1	200	Drop wise	30	30	103	1.73	~3%
G0-2	3:1	200	Drop wise	40	30	116	1.83	<1%
					60	129	1.94	
G0-4	3:1	200	Syringe pump	32	30	100	1.67	<1%
					60	113	1.78	
G0-5a	3:1	200	Semi-batch	34	30	86	1.66	<1%
					60	98	1.77	
G0-5b	3:1	300	Semi-batch	37	30	89	1.61	<1%
					60	95	1.68	
G0-7a	2.5:1	300	Semi-batch	37	30	91	1.66	<1%
					60	105	1.74	
G0-7b	2.5:1	300	Semi-batch	38	30	92	1.65	Trace
					120	133	2.16	
G0-8	3.5:1	300	Semi-batch	30	30	85	1.68	Trace
					60	99	1.78	

2 <sup>a</sup> Linear polymer metalated for 4 h at -20 °C with *sec*-BuLi, G0-1 polymerization at -35 °C,  
3 other reactions at -78 °C, 50 equiv styrene-DIPB monomer mixture used

4 [00105] The SEC traces obtained for the synthesis of G0 copolymers by three different  
5 addition methods are compared in Figure 7. The semi-batch addition protocol clearly  
6 produces a lower molecular weight and a narrower MWD for the G0 copolymer than the  
7 other protocols. This is seen in Table 3 for sample G0-5a (semi-batch addition), as compared  
8 to G0-2 (manual addition) and G0-4 (syringe pump addition).

9 [00106] **Example #8: Synthesis of G1 Styrene Arborescent Polymers**

10 [00107] The G0 styrene-DIPB copolymer remaining in the flask (2.9 g polymer in 100 mL  
11 THF) was diluted with 400 mL THF, and 5.4 mmol *sec*-BuLi (4.0 mL, for 24 % metalation  
12 based on the styrene and DIPB units in the side chains, 95% metalation based on DIPB units  
13 alone) were added at -20 °C. After 4 h, the flask was cooled to -78 °C, and LiCl (1.4 g in 50  
14 mL THF, 6:1 ratio with respect to initiator) was added from an ampule, as well as 27.0 g  
15 styrene (for a calculated side chain  $M_n = 5000$ ) by syringe. After 2 min, the polymerization  
16 was terminated with degassed methanol. The polymer (29.3 g, 99% yield) was recovered by  
17 precipitation in methanol and fractionated with toluene as solvent and methanol as nonsolvent

1 to remove linear polymer contaminant. The polymers were dried under vacuum for 24 h and  
2 analyzed by SEC, and  $^1\text{H}$  NMR spectroscopy. The absolute  $M_w$  of samples was measured by  
3 light scattering.

4 [00108] The results obtained for the synthesis of G1 arborescent polystyrenes with a target  
5 side chain  $M_n = 5000$  and using a backbone metalation level of 94% based on isopropenyl  
6 units are presented in Table 4. Sample G1-1 formed a gel only 10 min after the addition of  
7 styrene. However there was no significant gel formation (2 mg/mL solution in THF easily  
8 filterable through a 0.45  $\mu\text{m}$  filter) if the polymerization is terminated 2 min after styrene  
9 addition. Gel formation occurs as a result of cross-linking.

10 [00109] **Table 4. Synthesis of G1 polystyrenes by sub-stoichiometric activation<sup>a</sup>**

Sample	St:DIPB	Reaction time / min	G1 Polymer			Linear polymer (%) <sup>SEC</sup>
			$M_w^{\text{GPC}} / 10^5$	$M_w^{\text{LS}} / 10^6$	$M_w/M_n$	
G1-1	3:1	2	7.1		1.20	31
		10	Gel			
G1-4	3:1	2	7.9		1.19	9
G1-5a	3:1	2	7.6		1.25	9
G1-5b	3:1	2	7.3	5.8	1.22	9
G1-7a	2.5:1	2	8.1		1.23	10
G1-7b	2.5:1	2	10.6	15.7	1.24	4
G1-8	3.5:1	2	7.3		1.21	7

11 <sup>a</sup> G0 polymer metalated for 4 h at -20 °C with 0.92 equiv *sec*-BuLi, target side chain  $M_n =$   
12 5000, polymerization at -78 °C.

13 [00110] In Table 4 it can be seen that even though all the G0 substrates used in the  
14 reactions (Table 3) had a polydispersity index over 1.6, the G1 polymers obtained all had  
15  $M_w/M_n \leq 1.25$ . As the side chain length increases, the MWD gradually becomes narrower.  
16 One possibility for this effect could be reactive site differentiation on the polyfunctional  
17 initiator substrates. Since polymers at the high molecular weight end of the MWD contain

1 more initiating sites, intramolecular association may be unfavored for these molecules,  
2 making a fraction of the initiating sites less accessible, and thus self-regulating the growth of  
3 the molecules in the reaction mixture. A second reason could be that as the side chain length  
4 increases, the radius of gyration of all the polymers becomes comparable, thus producing a  
5 narrower range of SEC elution volume for the sample. A third possibility could be a  
6 separation artefact on the SEC column, due to decreasing separation efficiency of the  
7 columns in the high molecular weight range.

8 [00111] The amount of linear polymer generated in the reactions due to the presence of  
9 residual DIPB is provided in the last column of Table 4. Sample G1-1, synthesized from  
10 precursor G0-1, contained as much as 31% linear polymer contaminant. This is because the  
11 G0 precursor used was only allowed to react for 30 min after completion of the mixed  
12 monomer addition, and contained a significant amount of residual DIPB monomer. All the  
13 other G1 polystyrene samples, synthesized from G0 substrates 60 min after monomer mixture  
14 addition, contained less than 10% linear contaminant in the crude product. Samples G1-7a  
15 and G1-7b were synthesized from the same linear polymer (L7), but from G0 substrates  
16 obtained after different reaction times. To this end,  $\frac{1}{2}$  of the reaction mixture was removed  
17 after 1 h and used to generate G1-7a. The remaining  $\frac{1}{2}$  of the reaction mixture in the flask  
18 was allowed to react 1 h longer and used to generate G1-7b. Clearly, a longer polymerization  
19 time for the G0 polymerizations yields less linear polymer. However since a longer waiting  
20 time in the synthesis of the G0 polymer also increases the probability of dimerization or  
21 cross-linking, a compromise must be drawn between producing less linear polymer and  
22 obtaining a narrower MWD. Because unreacted DIPB in the G0 polymer synthesis can be  
23 activated by *sec*-BuLi and generate linear polymer, one must find a compromise between a  
24 narrow MWD and less linear polymer generation.

25 [00112] The influence of the waiting time in the G0 substrate synthesis on the amount of  
26 linear polymer obtained in the G1 polymer synthesis is illustrated in Figure 8 with SEC  
27 curves obtained for polymerization times varying from 30 min to 2 h. The leftmost peak in  
28 the SEC traces is for the G1 arborescent polystyrene, and the rightmost bimodal peak  
29 corresponds to the linear polymer. While a 30 min wait in the G0 polymer synthesis produces  
30 a large amount of linear polymer, very little linear contaminant is obtained after 1 h. The  
31 linear polymer has a bimodal distribution because either one or both isopropenyl moieties of  
32 DIPB can be activated. A series of SEC elution curves is provided in Figure 9 for linear, G0,

1 and G1 polystyrene samples obtained using "optimal" reaction conditions corresponding to  
2 sample G1-5b.

3 [00113] Example #9: One-Pot Synthesis Of Analogous Arborescent Polymers With  
4 Different Side Chain Molecular Weights

5 [00114] The one-pot synthesis of G0 and G1 arborescent polystyrenes, arborescent  
6 polystyrene-*graft*-(polystyrene-*block*-P2VP) and arborescent polystyrene-*graft*-poly(*t*BMA)  
7 with different side chain molecular weights and the same branching functionality was  
8 achieved by activating the linear and G0 styrene-DIPB copolymers with an excess of *sec*-  
9 BuLi (110% initiator based on DIPB units) at -20 °C, followed by several cycles of monomer  
10 addition (at -78 °C for styrene and 2VP, and at -20 °C for *t*BMA) and sample removal.

11 [00115] The synthesis of two series of analogous G0 and G1 arborescent polystyrenes is  
12 illustrated Table 5. In each series, the amount of monomer added at each step was adjusted to  
13 obtain side chains with a target  $M_n = 2500, 5000, 10000$  and 20000 based on the same  
14 substrate. To avoid cross-linking (gelation) during the extended reaction times required for  
15 the multiple monomer additions, a 10% excess *sec*-BuLi was used to ensure complete  
16 activation of the isopropenyl moieties on the styrene-DIPB copolymer substrates.

17 Table 5. Synthesis of analogous G0 and G1 polystyrenes<sup>a</sup>

Substrate	Target $M_n^{SC}$ $/ 10^3$	$M_w$ $/ 10^3$		$M_w/M_n$ (SEC)	Linear Polymer /%
		SEC	MALLS		
Linear	2.5	140	95	1.50	2
	5.0	230	280	1.47	4
	10	710	770	1.39	8
	20	880	1500	1.26	10
G0	2.5	600	2550	1.36	10
	5.0	640	5500	1.22	14
	10	660	9100	1.17	15
	20	890		1.13	18

18 <sup>a</sup> Substrate metalation level of 110% based on DIPB content;  $M_w$ (SEC) = 9100,  $M_w/M_n = 1.50$  for linear  
19 substrate;  $M_w$ (SEC)=125000,  $M_w/M_n = 1.69$  for G0 substrate; 6 equiv LiCl added after metalation

20 [00116] A typical procedure for the synthesis of a series of arborescent G1 polystyrenes  
21 differing in side chain molecular weight is as follows. The 1-L five-neck reactor assembly  
22 and preparation methods used were generally the same as previously described, but included

1 a styrene ampule (37.8 g in 380 mL THF) and a sampling tube. The synthesis of the G0  
2 styrene-DIPB copolymer was conducted as described above. For the G1 copolymer synthesis,  
3 the G0 styrene-DIPB copolymer (1.50 g in 50 mL THF) was diluted to 400 mL with THF.  
4 The reaction mixture was titrated with *sec*-BuLi to a light brown color, followed by 3.6 mmol  
5 *sec*-BuLi (2.7mL, for 27.5 % metalation based on the styrene and DIPB units in backbone,  
6 110% metalation based on DIPB units alone). After 4 h activation at -20 °C, the reaction  
7 mixture was cooled to -78 °C, a solution of LiCl (1.20 g) in 50 mL THF was added to the  
8 reactor, followed by slow addition of 90 mL of the styrene-THF solution (for a target side  
9 chain  $M_n = 2500$ ). A quick color change from brown to yellow was observed. After 10 min  
10 polymerization at -78 °C, an aliquot of polymer solution (185 mL; corresponding to 3.5 g  
11 polymer) was transferred through the sampling tube into a nitrogen-purged graduated funnel  
12 where the polymer was terminated with degassed methanol. After a second monomer  
13 addition (6.0 g styrene in 60 ml THF, for a total side chain target  $M_n = 5000$ ) and 20 min  
14 waiting, 115 mL polymer solution (corresponding to 3.5 g polymer) was removed as above  
15 and terminated. A third aliquot of styrene solution (8.7 g in 87 ml THF, for a total side chain  
16 target  $M_n = 10000$ ) was added. After 30 min, 78 mL polymer solution (3.5 g polymer) was  
17 removed and terminated. A fourth aliquot of styrene (14.2 g in 142 ml THF solution, for a  
18 total side chain target  $M_n = 20000$ ) was added. After 40 min, the polymerization was  
19 terminated by injecting degassed methanol into the reactor. All polymers were recovered by  
20 precipitation into methanol and characterized by SEC. The crude graft polymers were  
21 purified by precipitation fractionation using toluene as solvent and methanol as non-solvent,  
22 to remove linear polystyrene contaminant. The polymers were dried under vacuum for 24 h,  
23 and analyzed by MALLS to determine their absolute molecular weight. The G0 polystyrene  
24 sample series was synthesized by a similar procedure, using a linear styrene-DIPB copolymer  
25 substrate.

26 [00117] Example # 10 Synthesis of Arborescent Polystyrene-*graft*-(Polystyrene-*block*-  
27 Poly(2-Vinylpyridine)) Copolymer

28 [00118] A typical procedure for the synthesis of the arborescent G1 P2VP copolymers is  
29 as follows. The reactor assembly and preparation methods were generally the same as  
30 described above for the synthesis of arborescent polystyrenes with different side chain  
31 lengths, but included a 2VP ampule (32.9 g in 330 mL THF) in place of the styrene ampule.  
32 The synthesis of the G0 styrene-DIPB copolymer was conducted as described above. For the

1 Gl copolymer synthesis, the G0 polymer solution in THF (1.1 g) was diluted to 400 mL with  
2 THF, and 2.5 mmol *sec*-BuLi (1.8 mL, for 27.5 % metalation based on the styrene and *m*-  
3 DIPB units in the side chains, 110% metalation based on *m*-DIPB units alone) were added in  
4 the activation step. After 4 h metalation at -20 °C, the reaction mixture was cooled to -78 °C  
5 and a LiCl solution (0.70 g in 50 ml THF) was added to the reactor, followed by 7.5 g  
6 styrene (for a calculated  $M_n = 3000$ ) through a gas tight syringe to obtain the G1 styrene  
7 homopolymer. After 10 min, a sample was removed for SEC characterization. A 66 mL  
8 aliquot (6.6 g 2VP) of the 2VP solution (for a total side chain target  $M_n = 5500$ ) was slowly  
9 added to the reactor. A quick color change from brown to red was observed. After 10 min  
10 polymerization at -78 °C, an aliquot of polymer solution (115 mL, corresponding to 3.5 g  
11 polymer) was transferred through the sampling tube into a nitrogen-purged graduated funnel  
12 where the polymer was terminated with degassed methanol. After a second monomer  
13 addition (6.0 g 2VP in 60 ml THF, for a total side chain target  $M_n = 8000$ ) and 20 min  
14 waiting, 90 mL polymer solution (corresponding to 3.5 g polymer) was removed as above  
15 and terminated. A third aliquot of 2VP solution (8.0 g in 80 mL THF, for a total side chain  
16 target  $M_n = 13000$ ) was added. After 30 min, 70 mL polymer solution (3.5 g polymer) was  
17 removed and terminated. A fourth aliquot of 2VP (13.4 g in 134 mL THF solution, for a total  
18 side chain target  $M_n = 23000$ ) was added. After 40 min, the polymerization was terminated  
19 by injecting degassed methanol into the reactor. All polymers were recovered by precipitation  
20 into hexane and characterized by SEC analysis. The crude graft polymers were purified by  
21 precipitation fractionation using 4/1 THF/MeOH as solvent and hexane as non-solvent, to  
22 remove linear polystyrene-*block*-P2VP contaminant. The recovered polymer was dried under  
23 vacuum for 24 h, and analyzed by light scattering for absolute molecular weight and by NMR  
24 spectroscopy for composition. The G0 copolymers were synthesized using a similar  
25 procedure except for using the linear styrene-DIPB copolymer as substrate.

26 [00119] The results for the synthesis of aborescent G0 and G1 aborescent polystyrene-  
27 *block*-P2VP copolymers with  $M_n = 3000$  for the polystyrene block and  $M_n = 2500, 5000,$   
28  $10000$ , or  $20000$  for the P2VP block based on successive monomer additions are summarized  
29 in Table 6. The excess *sec*-BuLi used in the activation step led to the generation of a small  
30 amount of linear polystyrene-*block*-P2VP copolymer.

31 [00120] Comparing the SEC results of Table 6 with those obtained for the precursors, it is  
32 again clear that even though the linear and G0 substrates had relatively broad MWD, the G0

1 and G1 P2VP copolymers all had a narrower MWD. This is the same phenomenon observed  
2 in the synthesis of G0 and G1 polystyrene with different side chain lengths, and may have a  
3 similar origin. The last column in Table 6 gives the amount of new generation of linear  
4 polymers generated from residual DIPB and/or excess *sec*-BuLi. It can be seen that the linear  
5 polymer content varies from 12-34%, depending on the generation number of the substrate  
6 used and the molecular weight of the side chains. It may be possible to decrease the  
7 generation of linear polymer in these reactions by decreasing somewhat the excess of *sec*-  
8 BuLi used in the metalation step.

9 [00121] The absolute molecular weight of the copolymers was determined by SEC  
10 analysis using a MALLS detector for the G0 samples, and with batch-wise static light  
11 scattering measurements for the G1 copolymers. The apparent molecular weights measured  
12 by SEC analysis using a linear polystyrene standards calibration curve are much lower than  
13 those determined by light scattering, due to the compact structure of the branched polymers.

1 Table 6. Synthesis of analogous polystyrene-*graft*-(polystyrene-*block*-P2VP) copolymers<sup>a</sup>

Substrate	Target $M_n^{SC}$ of P2VP $/ 10^3$	$M_w$ $/ 10^3$		$M_w/M_n$ (SEC)	P2VP / %		Linear Polymer / %
		SEC	MALLS		Cal	NMR	
Linear	3.0 PS	80	110	1.48	0		12
	2.5	81	160	1.44	45	30	15
	5.0	130	220	1.38	63	56	18
	10	190	400	1.25	77	82	23
	20	280	1150	1.18	87	91	28
G0	3.0 PS	440	1400	1.67			23
	2.5	400	3100	1.31	45	43	26
	5.0	471	5400	1.25	63	66	29
	10	608	7300	1.24	77	87	32
	20	743	12200	1.21	87	95	34

- 2 <sup>a</sup> Substrate metalation level of 110% based on DIPB content.  $M_w$  (SEC) = 9000,  $M_w/M_n$  = 1.48 for linear substrate;  $M_w$  (SEC) = 125000,  $M_w/M_n$  = 1.70 for G0 substrate; 6 equiv LiCl added after metalation
- 5 [00122] Example #11: Synthesis Of Arborescent Polystyrene-*graft*-Poly(*t*-Butyl
- 6 Methacrylate) Copolymer

1 [00123] A typical procedure for the synthesis of arborescent G1 poly(*t*BMA) copolymers  
2 is as follows. The reactor assembly and preparation were generally the same as above  
3 described for the synthesis of arborescent polystyrenes with different side chain lengths,  
4 except that a *t*BMA ampule (38.2 g *t*BMA in 380 mL THF) was used in place of the styrene  
5 ampule. The synthesis of the G0 styrene-DIPB copolymer was conducted as described above.  
6 For the G1 copolymer synthesis, 1.50 g of the G0 styrene-DIPB copolymer in 50 mL THF  
7 was diluted with THF to 400 mL. The reaction mixture was titrated with *sec*-BuLi to a light  
8 brown color, before adding 3.6 mmol *sec*-BuLi (2.7 mL, for 27.5 % metalation based on the  
9 styrene and DIPB units in backbone, 110% metalation based on DIPB units alone). After 4 h  
10 metalation at -20 °C, a LiCl solution (1.20 g in 50 mL THF) was added to the reactor,  
11 followed by 90 mL *t*BMA-THF solution (for a target side chain  $M_n = 2500$ ). A quick color  
12 change from brown to faint green was observed. After 20 min polymerization at -20 °C, an  
13 aliquot of polymer solution (185 mL, corresponding to 3.5 g polymer) was transferred  
14 through the sampling tube into a nitrogen-purged graduated funnel where the polymerization  
15 was terminated with degassed methanol. After a second monomer addition (6.0 g *t*BMA in 60  
16 mL THF, for a total side chain target  $M_n = 5000$ ) and 30 min waiting, 115 mL polymer  
17 solution (corresponding to 3.5 g polymer) was removed as above and terminated. A third  
18 aliquot of *t*BMA solution (8.7 g in 87 mL THF, for a total side chain target  $M_n = 10000$ ) was  
19 added. After 40 min, 78 mL polymer solution (3.5 g polymer) was removed and terminated.  
20 A fourth aliquot of *t*BMA (14.2 g in 142 mL THF solution, for a total side chain target  $M_n =$   
21 20000) was added. After 60 min, the polymerization was terminated by injecting degassed  
22 methanol in the reactor. All polymers were recovered by precipitation into a 4:1  
23 methanol:water mixture and characterized by SEC analysis. The crude graft polymers were  
24 purified by precipitation fractionation using acetone as solvent and methanol as non-solvent,  
25 to remove linear poly(*t*BMA) contaminant. The recovered polymers were dried under  
26 vacuum for 24 h, and analyzed by MALLS for absolute molecular weight and NMR  
27 spectroscopy for composition. The G0 poly(*t*BMA) copolymer series was synthesized by a  
28 similar procedure except for using a linear styrene-DIPB copolymer as substrate.

29 [00124] Results for the synthesis of arborescent G0 and G1 PtBMA are summarized in  
30 Table 7. In analogy to the polystyrene and poly(2-vinylpyridine) systems,  $M_w/M_n$  decreases  
31 as the side chain length of the polymers increases. The linear polymer content of the crude

- 1 products increased with increasing side chain molecular, suggesting that the linear polymer  
 2 grew faster than the side chains of the branched polymer.
- 3 [00125] The absolute molecular weights from MALLS analysis are much higher than the  
 4 apparent values, due to the compact structure of the branched polymers.
- 5 [00126] **Table 7. Synthesis of analogous polystyrene-graft-PtBMA copolymers<sup>a</sup>**

Substrate	$M_n^{SC}$ / $10^3$	$M_w / 10^3$		$M_w/M_n$ (SEC)	Linear Polymer / %
		SEC	MALLS		
Linear	2.5	100	124	1.50	6.3
	5.0	210	230	1.41	9.2
	10	510	1000	1.23	12.8
	20	760	1500	1.16	14.0
G0	2.5	420	490	1.43	8.7
	5.0	620	1120	1.25	13.7
	10	760	1820	1.23	21.4
	20	890	3350	1.18	27.8

- 6 [00127] All publications, patents and patent applications are herein incorporated by  
 7 reference in their entirety to the same extent as if each individual publication, patent or patent  
 8 application was specifically and individually indicated to be incorporated by reference in its  
 9 entirety
- 10 [00128] Although the invention has been described with reference to certain specific  
 11 embodiments, various modifications thereof will be apparent to those skilled in the art  
 12 without departing from the spirit and scope of the invention as outlined in the claims  
 13 appended hereto.
- 14